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D3582-1-BENT
Job Sheet 204012



Part No: D3582-1-BENT

Job Qty: 4 pcs

Part Name: Skidtube Assembly BK117



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/2/19

Job Tracking No:

Due Date: 12/27/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3582 page 1 REV.E SHEET 1 IPP REV:A 14.01.17 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	4 pcs	12/27/19	12/27/19	0.00	2.00	Skidtubes - Bend		MCA
120	QC 5	4 pcs	12/27/19	12/27/19	0.00	0.00	QC 5 - 10		BF
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		



Container No: S237668



Part: D3582-1-BENT

Job No: 204012

Serial No/Batch: S237668

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/05/19

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					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	BE
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	4 pcs	12/27/19	0.00 0.00		QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	8.00

Part Op 110 - (CNC Delta 100 Bender) Bend tube as per program D3582 on CNC Bender and Dwg D3582. Folio 3, use bending
Descriptions: aid DT9632 2- cut fwd end of tube as per dwg
120 - (QC5-Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location: LG002) LOCATION : LG002
140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2962-150	3.540 Outer Tube, Extrut	4 pcs (1 ea)	110-Skidtubes - Bend - 1	5175 497

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - Bend - 1	D2962-150	4	21	0

Part Specifications	
Specifications could not be found.	

ITEM	Qty	Part Number	Description
-041	X	D3582-041	SKIDTUBE ASSEMBLY
1	1	D2682-150	EXTRUSION
2	1	D2684	CAP
3	1	D2685	CAP
4	1	D2671	CROSS BOLT SPACER
5	1	D3506-3	WEARPLATE
6	1	D3508-8	WEARPLATE
7	1	D3508-11	WEARPLATE
8	1	D3508-13	WEARPLATE
9	1	D3558-3	GASKET
10	1	D3558-8	GASKET
11	1	D3558-11	GASKET
12	1	D3558-13	GASKET
13	1	D3584-1	WEB
14	3	D3682-1	CROSS BOLT SPACER
15	1	D3682-3	CROSS BOLT SPACER
16	2	D3304-1	CROSS BOLT SPACER
17	2	D5522-1	DOUBLER
18	28	AN3C4A	BOLT
19	2	AN3-5A	BOLT
20	2	AN4-4A	BOLT
21	28	NA511480332R	WASHER (AN880C10L)
22	2	NA511480332J	WASHER (AN880JD10L)
23	2	NA5114800416J	WASHER (AN880JD416L)
24	38	AEL8-1032-130	INSERT
25	2	AL57-428-165	INSERT
26	68	CR3272-5-05	CSK RIVET, CHERRY MAX

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.3.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 18.2 lbs
- 8) WELDING: PER DART QSI 004.
- 9) INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-281 ADHESIVE PER DART QSI D15 AFTER BENDING.
- 10) USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL Ø0.207 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AEL8-1032-130 PER SECTION G-G (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-281.
- 11) DO NOT INSTALL AN3C4A BOLTS AND NA511480332R WASHERS IN INDICATED LOCATIONS
- 12) LOCATE QTY (34) HOLES ONTO THE SKIDTUBE PER D5520-1 DOUBLER AND DRILL Ø0.161 THRU SKIDTUBE AND DOUBLER USING DT10308. COUNTERSINK Ø0.288 x 100° (34 PL) PER DOUBLER AND INSTALL EACH D5520-1 DOUBLER USING QTY (34) CR3212-5-05 CSK RIVETS.

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2017-08-11
EW 17-547

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WORK ORDER
NO. 204012
1105
6912-02

E	MOVE VIEWS FROM SHT 1 TO SHT 2. ADD ITEMS 17 & 28 AND NOTE 12-13. Ø0.187 HOLE WAS Ø0.176. ADD SHT 3, ADD DETAIL J. SECTION F-F ADD D5520-1. SCALE ON VIEWS WAS 3X.	AJS	17.03.27
D	D3584-1 WAS D2672; REVISE BOM & SECTION F-F & SECTION NOTES (2N B7-3, A8-3); REF NCR18-5160	RF	17.01.09
C	D3482 PILING ASSEMBLIES REMOVED. REFORMAT NOTES SHT 1	AP	16.11.02
B	23.88 WAS 23.87 (2N C2-1). INCORPORATED DEO D3552-1-1 (2N C2-1). FORMAT TO CURRENT STD	RF	16.02.20
A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	AJS		
CHECKED	WZL		
INFO. APPR.	DJ		
APPROVED	DJ		
DE APPR.	4	TITLE	SCALE
DATE	17.03.27	8K 117 SKIDTUBE ASSEMBLY	NTS
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